

Part No: K10003

Part Name: Saddles



Part Weight: 0 lbs

Job Created: 3/6/18

Due Date: 3/30/18

Status: Scheduled

Priority: Medium

Job Qty: 4 ea

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note:

DWG REV H IPP: 03.01.16 Reformat: Incorporated D205-64-1-011 KJ/RF IPP : J 06-07-25 As per DSI 9344

JLM IPP : K 06.11.17 Per K10003 Rev C KJ IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified: IPP N 09.01.27 DSI 9418 rev B EC verified: DD

IPP Rev:O 11.03.11 per ds19536 DD ver:EC IPP REV:P 12.01.23 AS PER ECN11-684 VERF:EC

Bill of Materials									
Job Routing									
Op	No	Operation	Qty	Start Date	Due Date	Setup Run	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	4 Ea	3/30/18	0.00	0.00	Start Up Stores/Pkg-1	Workcenter / Supplier	9-88	MAR 16 2018
110	Packaging	4 pcs	3/30/18	0.00	0.00	Packaging1-5	Workcenter / Supplier	9-88	MAR 16 2018
120	QC	4 pcs	3/30/18	0.00	0.00	QC4	Workcenter / Supplier	9-88	MAR 16 2018
125	DC	4 pcs	3/30/18	0.00	0.00	DC	Workcenter / Supplier	9-88	MAR 16 2018
130	Packaging	4 pcs	3/30/18	0.00	0.00	Packaging3-2	Workcenter / Supplier	9-88	MAR 16 2018
140	QC21-FG	4 Ea	3/30/18	0.00	0.00	QC21	Workcenter / Supplier	9-88	MAR 16 2018
Part Op 125 - Create White labels only per PPP K10003 CHG 0010									
Descriptions:									

Part / Item	Component Name	Quantity	Operation	Container
AN4-51A	Bolt	32 Ea (8 ea)	90-Start up Operation	
AN4-6A	Bolt	64 Ea (16 ea)	90-Start up Operation	
AN4C46A	Bolt	16 Ea (4 ea)	90-Start up Operation	
AN6-12A	Bolt	32 Ea (8 ea)	90-Start up Operation	
D2570	Bushing	96 Ea (24 ea)	90-Start up Operation	
D2571	Saddle, Fwd, Out	4 Ea (1 ea)	90-Start up Operation	
D2572	Saddle, Fwd, In	4 Ea (1 ea)	90-Start up Operation	
D2573	Saddle, Aft, Out	4 Ea (1 ea)	90-Start up Operation	
D2574	Saddle, Aft, In	4 Ea (1 ea)	90-Start up Operation	
D2747	Set Screw	16 Ea (4 ea)	90-Start up Operation	
D2876	Saddle Spacer	8 Ea (2 ea)	90-Start up Operation	
D2877	Saddle Spacer	8 Ea (2 ea)	90-Start up Operation	
D3405-041	Ground Handling Lug	4 Ea (1 ea)	90-Start up Operation	
D3405-043	Ground Handling Lug	4 Ea (1 ea)	90-Start up Operation	
D3407-041	Tow Ring	4 Ea (1 ea)	90-Start up Operation	
D3417-5	Washer	8 Ea (2 ea)	90-Start up Operation	
D3456-1	Washer	4 Ea (1 ea)	90-Start up Operation	
D3533-1	Set Screw	8 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	96 Ea (24 ea)	90-Start up Operation	
MS21043-4	Nut	20 Ea (5 ea)	90-Start up Operation	
NAS1149D0463J	Washer	128 Ea (32 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss, ☐ Folio/Progr: ☐ Grain ☐ Weld ☐ Wrong Stoc ☐ Out of Seq. ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐			
		OTHER :		Turning Sequence ☐	

Part: K10003
 Job No: 173710
 Serial No/Batch: S052356
 Revision: _____
 Inspector: _____

Date: 02/16/18

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 Newbury, ON K4A 1K7
 CANADA
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 www.dartaero.com

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-51A	32	254	0
	AN4-6A	64	804	0
	AN4C46A	16	245	0
	AN6-12A	32	397	0
	D2570	96	799	0
	D2571	4	30	0
	D2572	4	28	0
	D2573	4	23	0
	D2574	4	18	0
	D2747	16	140	0
	D2876	8	13	0
	D2877	8	30	0
	D3405-041	4	15	0
	D3405-043	4	2	0
	D3407-041	4	26	0
	D3417-5	8	21	0
	D3456-1	4	81	0
	D3533-1	8	38	0
	MS21042L4	96	3,860	0
	MS21043-4	20	863	0
	NAS1149D0463J	128	5,081	0
	NAS1149D0663J	32	1,698	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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1270 Aberdeen St
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Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001625	S051350	AN4-51A	Bolt	S044185	OVER003	32
001625	S051349	AN4-6A	Bolt	s019399	ST345	64
001625	S051348	AN4C46A	Bolt	s006303	ST341	16
001625	S051255	AN6-12A	Bolt	s024842	ST335	32
001625	S006432	D2570	Bushing		FP001	1
001625	S043547	D2570	Bushing	S007170	ST008	84
001625	S050998	D2570	Bushing	s046933	ST008	11
001625	S050817	D2571	Saddle, Fwd, Out	S043563	ST397	4
001625	S050818	D2572	Saddle, Fwd, In	S043561	ST397	4
001625	S038662	D2573	Saddle, Aft, Out	S038659	ST398	1
001625	S047910	D2573	Saddle, Aft, Out	S047908	ST398	1
001625	S052355	D2573	Saddle, Aft, Out	S046939	ST398	2
001625	S052354	D2574	Saddle, Aft, In	S046937	ST398	4
001625	F164972	D2747	Set Screw		ST010	12
001625	S050987	D2747	Set Screw	s031307	ST010	4
001625	S052021	D2876	Saddle Spacer	S051517	ST013	8
001625	S050970	D2877	Saddle Spacer	s042020	ST013	8
001625	S020816	D3405-041	Ground Handling Lug	S038088	ST529	3
001625	S050841	D3405-041	Ground Handling Lug	S026304	ST529	1
001625	S050820	D3405-043	Ground Handling Lug	S048816	ST529	4
001625	S050836	D3407-041	Tow Ring	S043180	ST530	4
001625	S050956	D3417-5	Washer	S049482	ST034	8
001625	S050951	D3456-1	Washer	s012112	ST036	4
001625	S050924	D3533-1	Set Screw	s019132	ST038	8
001625	S050916	MS21042L4	Nut	s045901	ST303	96
001625	S050911	MS21043-4	Nut	s038086	ST302	20
001625	S027736	NAS1149D0463J	Washer		ST263	64
001625	S049080	NAS1149D0463J	Washer	S035926	ST263	14
001625	S050892	NAS1149D0463J	Washer	s045845	ST263	50
001625	S050864	NAS1149D0663J	Washer	s024481	ST263	32

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/16/18 1:41 PM dart.quirion.sonia

5.0 PARTS LIST

5.1 Skidtube Installations with Standard Wearshoes

Item	634 -011	634 -015	634 -041	634 -045	634 -047	641 -011	Part Number	Description
	X						D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X					D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X				D205-634-041	SKIDTUBE
		1		X			D205-634-045	SKIDTUBE
					X		D205-634-047	WEARSHOE KIT
	1	1				X	D205-641-011	GROUND HANDLING KIT
1			1				D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1			D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16			D2594-1	* PLUG
2B			16	16			D2594-3	* O-RING
3			1	1			D2855	* AFT CAP
4			2	2			AN3-5A	* BOLT
5			2	2			NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
7A			1	1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
8A			1	1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
9A			1	1	1		D3564-13	* WEARSHOE
10			50	50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50			ALS4-1032-130	* INSERT
13			2	2			ALS4-1032-225	* INSERT
20	1	1					D2571	SADDLE, FWD OUTSIDE
21	1	1					D2572	SADDLE, FWD INSIDE
22	1	1					D2573	SADDLE, AFT OUTSIDE
23	1	1					D2574	SADDLE, AFT INSIDE
24	8	8					AN4-51A	BOLT
25	16	16					D2570	BUSHINGS
26	8	8					MS21042L4	NUT (OR MS21042-4)
27	8	8					AN6-12A	BOLT
28	8	8					NAS1149D0668J	WASHER (AN960JD616)
29	16	16					AN4-6A	BOLT
30	32	32					NAS1149D0463J	WASHER (AN960JD416)
31	16	16					MS21042L4	NUT (OR MS21042-4)
32	4	4					D2747	SET SCREW
33	2	2					D3533-1	SET SCREW
40	1	1					D3407-041	TOW RING (REPLACES D2968-041)
41	1	1					D3456-1	WASHER
43	1	1					MS21043-4	NUT
44	2	2					D3417-5	WASHER
50						1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51						1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52						4	AN4C46A	BOLT
53						8	D2570	BUSHING
54						4	MS21043-4	NUT (OR MS21042-4)
60	2	2					D2876	SADDLE SPACER
61	2	2					D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE